



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2360**Job Sheet 199792****Part No:** D2360**Job Qty:** 10 pcs**Part Name:** Litter Tie Down Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/3/19**Job Tracking No:****Due Date:** 9/17/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		9/17/19	0.00	0.33	Bandsaw - 1		DJP 19-10-06 DJP 19-10-06
110	HAAS 4 Axis - B4B	10 pcs		9/17/19	0.26	14.93	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	10 pcs		9/17/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

**Container No:** S220113**Part:** D2360**Job No:** 199792**Serial No/Batch:** S220113**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/06/19

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9/3/2019

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130 QC 8	10 pcs	9/17/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	9/17/19	0.00 0.78	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	

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OCT 08 2019

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						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 - White GI(A)- B4B	10 pcs	9/17/19	0.00	0.50		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
160 QC 3	10 pcs	9/17/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
170 Small Fab - 2 - B4B	10 pcs	9/17/19	0.00	3.14		Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	
						Small Fab - 4 - B4B	
						Small Fab - 5 - B4B	
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
						Small Fab - 8 - B4B	
180 QC 5	10 pcs	9/17/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	

PL 19-10-8

START: 11:15 OUT: 3:30 FINISH: 11:45

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DAS 58 OCT 09 2019

DAS 81 OCT 10 2019

						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
190	Packaging 3-1 - Stock - B4B	10	9/17/19	0.00	0.00	Packaging 3 - 1 - B4B	
		pcs				Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	

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					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
200 QC 21 - SA	10 pcs	9/17/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	2-30 OCT 1 11 2019

Part Op 100 - (Bandsaw) Cut blanks: 12.65" Long
 Descriptions: 110 - (HAAS CNC vertical machine #1) 1-Machine as per Folio D2341 and Dwg D2341 2-Deburr
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Small Fab) Assemble as per dwg D2360
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Identify as per dwg & Stock Location: _____)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	10.5400 ft (1.054 ea)	100-Bandsaw - 1	5193613
AN526C1032R18	Screw	10 Ea (1 ea)	170-Small Fab - 2 - B4B	5216374
D2002-015	Knob	20 pcs (2 ea)	170-Small Fab - 2 - B4B	14523
D2345	Lock Channel	10 pcs (1 ea)	170-Small Fab - 2 - B4B	5194795
D2366	Lock Handle	20 pcs (2 ea)	170-Small Fab - 2 - B4B	5192123
D2367	Handle Knob	10 pcs (1 ea)	170-Small Fab - 2 - B4B	5190251
D2372	Quick Release	20 pcs (2 ea)	170-Small Fab - 2 - B4B	5162094
D2373	Spring	10 pcs (1 ea)	170-Small Fab - 2 - B4B	5201843
D2444	Pip Pin Assembly	10 pcs (1 ea)	170-Small Fab - 2 - B4B	5194046
MS20470AD3-4	Rivet, Universal Head	10 Ea (1 ea)	170-Small Fab - 2 - B4B	5212159
MS21042L3	Nut	30 Ea (3 ea)	170-Small Fab - 2 - B4B	51063
MS27039-1-13	Screw	10 Ea (1 ea)	170-Small Fab - 2 - B4B	5204223
MS27039-1-15	Screw	20 Ea (2 ea)	170-Small Fab - 2 - B4B	5071833
NAS1149D0332J	Washer	80 Ea (8 ea)	170-Small Fab - 2 - B4B	5114290
NAS1149D0363J	Washer	20 Ea (2 ea)	170-Small Fab - 2 - B4B	5178378
NAS679A3W	Nut	10 Ea (1 ea)	170-Small Fab - 2 - B4B	5201031
				5131213

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	11	39	0
170-Small Fab - 2 - B4B	AN526C1032R18	10	65	0
	D2002-015	20	67	0
	D2345	10	24	0
	D2366	20	51	0
	D2367	10	55	0
	D2372	20	94	0
	D2373	10	37	0
	D2444	10	27	0
	MS20470AD3-4	10	5,319	0
	MS21042L3	30	1,428	0
	MS27039-1-13	10	370	0
	MS27039-1-15	20	243	0
	NAS1149D0332J	80	2,293	0
	NAS1149D0363J	20	979	0
	NAS679A3W	10	25	0

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Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

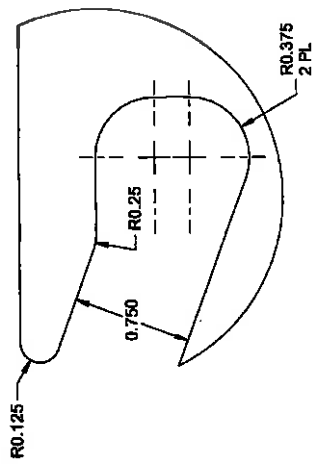
DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	

INSPECTION SHEET

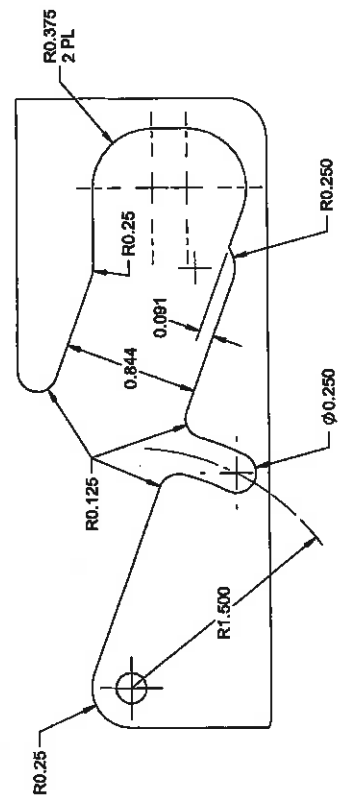
**DAS
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Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	
D	16.06.14	Dimensions updated per Dwg Rev G	KJ	

1 2 3 4 5 6 7 8



DETAIL B C4-1
SCALE 2X



DETAIL A C6-1
SCALE 2X

DESIGN	BW	DART AEROSPACE LTD
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA
CHECKED	AJS	DRAWING NO. D2341
MFG. APPR.	JLM	REV. G SHEET 2 OF 2
APPROVED	HS	TITLE LITTER TIE DOWN BRACKET (LOCKING) NTS
DE APPR.	DS	SCALE
DATE	15.11.12	DATE

APPROVED

RELEASED
R 2016-04-18

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